



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Rush Please

D4812-041
Job Sheet 180002



Part No: D4812-041

Job Qty: 5 ea

Part Name: Patient Stop Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/27/18

Job Tracking No:

Created By: Linda Lacelle

Due Date: 7/4/18

Type: Stock

Description:

Note: DWG REV B IPP REV:A 13.05.21 AS PER DWG REV.A VERF:JLM IPP REV:B 16.04.19 AS PER DWG REV.B VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	7/4/18	7/4/18	0.00	0.00	Start Up Waterjet		SC 18/06/18
100	Waterjet	5 pcs	7/4/18	7/4/18	0.00	1.33	Waterjet1		SC 18/06/18
110	QC	5 pcs	7/4/18	7/4/18	0.00	0.00	QC2 Waterjet-1		SC 18/06/18
120	QC	5 pcs	7/4/18	7/4/18	0.00	0.00	QC8-5		38
130	Small Fab	5 pcs	7/4/18	7/4/18	0.08	1.33	Small Fab-7		9-88
140	QC	5 pcs	7/4/18	7/4/18	0.00	0.00	QC5		IF
150	HandFinish	5 pcs	7/4/18	7/4/18	0.00	0.58	HandFinish1		SA 18-07-12
160	QC	5 pcs	7/4/18	7/4/18	0.00	0.00	QC7-4		18-7-13
170	Powdercoat	5 pcs	7/4/18	7/4/18	0.00	0.42	Powdercoat1		18-7-13
180	QC	5 pcs	7/4/18	7/4/18	0.00	0.00	QC3		ES
190	Small Fab	5 pcs	7/4/18	7/4/18	0.00	1.33	Small Fab-7		ES
200	QC	5 pcs	7/4/18	7/4/18	0.00	0.00	QC5		ES
210	Packaging	5 pcs	7/4/18	7/4/18	0.00	0.00	Packaging3-2	51208 80	JUL 31 2018
220	QC21-SA	5 Ea	7/4/18	7/4/18	0.00	0.00	QC21		21 AUG 01 2018

M38839

START: 8:15

OUT: 3:05

FINISH: 8:45

507696

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	10.1500 sf (2.03 ea)	90-Start up Operation	
D2690-6	Lanyard	10 Ea (2 ea)	190-Small Fab	5092636
D4811-1	Pin, Quick Release	10 Ea (2 ea)	190-Small Fab	5067034
MS21042L3	Nut	10 Ea (2 ea)	190-Small Fab	5078167
MS27039-1-07	Screw	10 Ea (2 ea)	190-Small Fab	5079112
NAS1149D0332J	Washer	30 Ea (6 ea)	190-Small Fab	5035396

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																	
Date : _____	Step #: _____	CTV 555		MRB (QSI042) Approval																																																																															
Dart Aerospace Ltd. 1270 Aberdeen Street Brampton, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 06/28/18 Container No: S088388 Part: D4812-041 Job No: 180002 Serial No/Batch: S088388				Completed By																																																																															
				Lead hand / Supervisor Approval Verification																																																																															
				QC / QA Coordinator Approval																																																																															
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%; text-align: center;">Root Cause</td> <td style="width:15%;"></td> <td style="width:15%; text-align: center;">FAULT CATEGORY</td> <td style="width:15%;"></td> <td style="width:15%; text-align: center;">Other</td> <td style="width:15%;"></td> </tr> <tr> <td>Environment</td> <td>☐</td> <td>Temperature/Load</td> <td>☐</td> <td>Power Loss/Surge</td> <td>☐</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Set-up</td> <td>☐</td> <td>Ratio/Program</td> <td>☐</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>RCM Fault</td> <td>☐</td> <td>Gain</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Broken/Damaged/Defect</td> <td>☐</td> <td>Weld</td> <td>☐</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Inspection Incomplete/Unqualified</td> <td>☐</td> <td>Wrong Stock Pulled</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Contamination</td> <td>☐</td> <td>Out of Sequence</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Countersink</td> <td>☐</td> <td>Off-set</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Cut Too Short</td> <td>☐</td> <td>Mislabeled</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Instructions Incomplete/Unclear</td> <td>☐</td> <td>Fit/Function</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Drill Holes</td> <td>☐</td> <td>Misaligned/off center</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>						Root Cause		FAULT CATEGORY		Other		Environment	☐	Temperature/Load	☐	Power Loss/Surge	☐	Design	☐	Set-up	☐	Ratio/Program	☐	Doc/Data	☐	RCM Fault	☐	Gain	☐	Equip/Tooling	☐	Broken/Damaged/Defect	☐	Weld	☐	Handling/Pre	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Material	☐	Contamination	☐	Out of Sequence	☐	Internal Transport	☐	Countersink	☐	Off-set	☐	Tribal Knowledge	☐	Cut Too Short	☐	Mislabeled	☐	LOA	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Substation	☐	Drill Holes	☐	Misaligned/off center	☐	Past Expiry Date	☐					Misidentified	☐				
Root Cause		FAULT CATEGORY		Other																																																																															
Environment	☐	Temperature/Load	☐	Power Loss/Surge	☐																																																																														
Design	☐	Set-up	☐	Ratio/Program	☐																																																																														
Doc/Data	☐	RCM Fault	☐	Gain	☐																																																																														
Equip/Tooling	☐	Broken/Damaged/Defect	☐	Weld	☐																																																																														
Handling/Pre	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐																																																																														
Material	☐	Contamination	☐	Out of Sequence	☐																																																																														
Internal Transport	☐	Countersink	☐	Off-set	☐																																																																														
Tribal Knowledge	☐	Cut Too Short	☐	Mislabeled	☐																																																																														
LOA	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐																																																																														
Substation	☐	Drill Holes	☐	Misaligned/off center	☐																																																																														
Past Expiry Date	☐																																																																																		
Misidentified	☐																																																																																		

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation 190-Small Fab	M6061T6S.063	10	300	0
	D2690-6	10	28	0
	D4811-1	10	14	0
	MS21042L3	10	1,324	0
	MS27039-1-07	10	98	0
	NAS1149D0332J	30	1,569	0
Part Specifications				
Specifications could not be found.				

Plex 6/27/18 2:08 PM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

